

Date: Tuesday, 12/12/2006 10:31:38 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 29898					
Estimate Number	: 11147					
P.O. Number	: <u>N/A</u>			Part Number	: D3209041	
This Issue	: 12/12/2006		S.O. No. : <u>N/A</u>	Drawing Number	: D3209 REV A	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: <u>N/A</u>		Type : MACHINED PARTS	Drawing Revision	: A	
Previous Run	: <u>N/A</u>			Material	: <u>N/A</u>	
Written By	: <u>JF 06/12/12</u>			Due Date	: 1/10/2007	
Checked & Approved By	: <u></u>			Qty:	6 Um: Each	
Comment	: Est A0406.09 New issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"	
		Comment: Qty.: 0.1838 f(s)/Unit Total : 1.1025 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1 Batch: <u>M101694</u>	
		J.F. 06/12/17	(6)
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)	
		J.F. 06/12/17	(6)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1 Deburr and Tumble	
		J.F. 06/12/18	(6)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		J.F. 06/12/18	(6)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
		J.G. 06/12/18	(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/12
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/12/2006 10:31:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29898

Part Number: D3209041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(6x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-B/4

06/12/27

7.0 POWDER COATING

POWDER COATING



M101601



(6x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the hole for D3209-1 before powder coat.

m-B/a.m

07/01/03

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m107/01/11

9.0 D32093

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description Batch

B22081 x1

1 D3209-3 Bushing

B29907 x5

Press fit bushing into the bracket as per Dwg D3209

x6

m107/01/11

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m107/01/11 (6)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 9416

BB 08/12/12 (6) 10/01/12

12.0 QC21

FINAL/INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/01/12

Job Completion



107/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29897
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

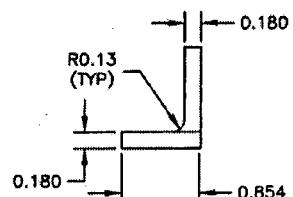
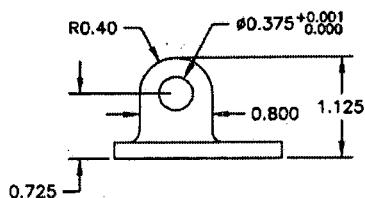
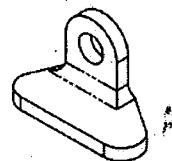
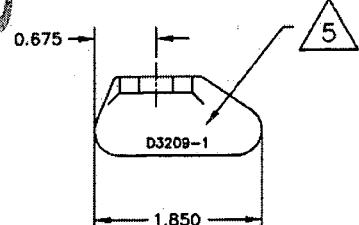
Measured by: <u>J.F.</u>	Audited by: <u>S.G.</u>	Prototype Approval: N/A
Date: <u>06/12/17</u>	Date: <u>06/12/17</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A.	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	✓

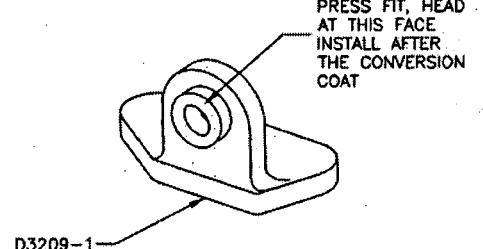
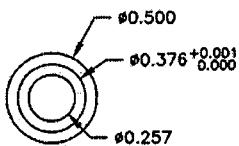
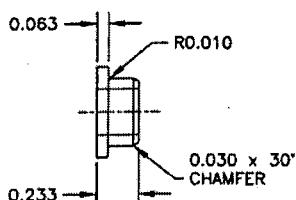
DART

DRAFT COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3209	SHEET 1 OF 1
DATE		TITLE	SCALE
04.01.27		BRACKET	1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 AF

D3209-1 BRACKET



D3209-041 ASSEMBLY

3

D3209-3 BUSHING
SCALE 1:2

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 29897

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